

S113953



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D3078-041
Job Sheet 183804



Part No: D3078-041

Job Qty: 2 ea

Part Name: Step Assembly, Hi Short LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No:

Due Date: 9/28/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP REV:A 15.11.12 NEW ISSUE DD VERF:JLM IPP REV:B 16.03.15 DWG REV:B DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		9/28/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	2 pcs		9/28/18	0.00	2.02	Large Fab 8		
120	QC	2 pcs		9/28/18	0.00	0.00	QC6		
130	Large Fab	2 pcs		9/28/18	0.00	2.02	Large Fab 2		
140	QC	2 pcs		9/28/18	0.00	0.00	QC9		
150	QC	2 pcs		9/28/18	0.00	0.00	QC5		
160	HandFinish	2 pcs		9/28/18	0.00	0.23	HandFinish1		
170	QC	2 pcs		9/28/18	0.00	0.00	QC7-2		
200	Large Fab	2 pcs		9/28/18	0.00	2.02	Large Fab 2		
210	QC	2 pcs		9/28/18	0.00	0.00	QC10		
220	QC	2 pcs		9/28/18	0.00	0.00	QC5		
240	HandFinish	2 pcs		9/28/18	0.00	0.23	HandFinish6		
250	Powdercoat	2 pcs		9/28/18	0.00	0.46	Powdercoat1		
260	HandFinish	2 pcs		9/28/18	0.00	0.23	HandFinish3		
270	QC	2 pcs		9/28/18	0.00	0.00	QC3		
290	Packaging	2 pcs		9/28/18	0.00	0.00	Packaging3-1		
300	QC21-SA	2 Ea		9/28/18	0.00	0.00	QC21		

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680
Descriptions: for rivets. 3-Deburr

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R
Aluminum Rod 1134785 3-Grind End Plate flush

200 - 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-
Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 5-Grind End Plate flush

250 - START TIME: 11:50 OVEN TEMPERATURE: 325 FINISH TIME: 12:20

Wing walk. 5098/20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (.5 ea)	90-Start up Operation	S104007 S112429
D3067-1	End Plate	4 Ea (2 ea)	130-Large Fab	S112750
D3219-3	Plate	4 Ea (2 ea)	130-Large Fab	S112751
D3065-041	Step Leg Assembly	2 Ea (1 ea)	200-Large Fab	S113870
D3066-1	Spacer	4 Ea (2 ea)	200-Large Fab	S113871
MS20600-AD4W4	Rivet	32 Ea (16 ea)	200-Large Fab	S106978

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	161	0
130-Large Fab	D3067-1	4	131	0
	D3219-3	4	45	0
200-Large Fab	D3065-041	2	14	0
	D3066-1	4	122	0
	MS20600-AD4W4	32	194	0

Part Specifications

Specifications could not be found.

Plex 9/26/18 3:32 PM Dart.Gagnon.Michelle

DART
AEROSPACE

Container No: S113953



Part: D3078-041

Job No: 183804

Serial No/Batch: S113953

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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